

Date: Thursday, 2/23/2006 10:23:16 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE, OUTBOARD, LH, 206
Job Number : 25915
Estimate Number : 10818
P.O. Number : N/A Part Number : D26651
This Issue : 2/23/2006 S.O. No. : N/A Drawing Number : D2665 REV. B
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : MACHINED PARTS Drawing Revision : B
Previous Run : 24847 Material : N/A
Written By : SEE COMMENT BELOW Due Date : 3/22/2006 Qty: 12 Um: Each
Checked & Approved By : 06.02.23
Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101003 7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
7075-T7351 2X6.25X7.875
Cut Size 2.0" x 6.25" x 7.88"
Grain Along Long 7.88 Length Batch no. B24891

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Program batch number.
1-Inspect part number and batch number are programmed correctly.
2-Fixturing W/O No. N/A
3-Fixturing Inspection last completed on 06.01.06 by SD
4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet
5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet
6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet
7- Deburr SD 06.07.06 (12)

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet SD 06.07.24 x 13

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE SD 06.07.06 (12)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: SP Date: 06/07/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/23/2006 10:23:17 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, LH, 206

Job Number: 25915

Part Number: D26651

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Jul 06/07/24

(12)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06/07/25

(12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SC 06/07/25

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AK 06/07/28

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST483*

AK 06/07/28

(12)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/07/28

(12)

Job Completion



AF 06.07.28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25915
Description: 206 Saddle, Outboard, Left side	Part Number:	D2665-1
Inspection Dwg: D2665 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.128	.126	.132	.132		
B	0.100	0.140		.130	.125	.132	.132		
C	0.100	0.140		.125	.119	.126	.126		
D	0.210	0.230		.219	.229	.227	.225		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	5.990	6.010		5.999	5.999	5.999	5.999		
H	0.510	0.515		0.515	0.515	0.515	0.515		
I	1.674	1.684		1.679	1.679	1.679	1.679		
J	2.495	2.505		2.497	2.497	2.497	2.498		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		0.237	0.237	0.237	0.237		
N	0.100	0.140		.121	.129	.127	.127		
O	0.540	0.560		.547	.547	.577	.547		
P	0.490	0.510		.499	.494	.499	.499		
Q	3.609	3.619		3.614	3.614	3.614	3.614		
R	2.470	2.510		2.499	2.495	2.499	2.499		
S	0.240	0.270		.251	.248	.258	.259		
T	0.100	0.180		.140	.141	.143	.142		
U	0.313	0.318	DT8686	/	/	/	/		
V	1.125	1.145		1.134	1.143	1.132	1.132		
W	1.565	1.585		1.572	1.583	1.571	1.571		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SD	Audited by: JME
Date: 06.07.06 / 06/07/24	Date: 06/07/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683; DT8686	KJ/RF	

DART AEROSPACE LTD	Work Order:	25915
Description: 206 Saddle, Outboard, Left side	Part Number:	D2665-1
Inspection Dwg: D2665 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.131	.129	.129	.129		
B	0.100	0.140		.134	.131	.129	.130		
C	0.100	0.140		.126	.122	.124	.122		
D	0.210	0.230		.221	.223	.221	.223		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	5.990	6.010		6.000	5.999	6.000	5.999		
H	0.510	0.515		0.515	0.515	0.515	0.515		
I	1.674	1.684		1.679	1.679	1.679	1.679		
J	2.495	2.505		2.498	2.498	2.498	2.498		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		0.237	0.237	0.237	0.237		
N	0.100	0.140		.119	.121	.118	.120		
O	0.540	0.560		.548	.545	.545	.547		
P	0.490	0.510		.496	.495	.498	.496		
Q	3.609	3.619		3.614	3.614	3.614	3.614		
R	2.470	2.510		2.498	2.499	2.499	2.499		
S	0.240	0.270		.258	.255	.256	.255		
T	0.100	0.180		.145	.145	.145	.145		
U	0.313	0.318	DT8686						
V	1.125	1.145		1.132	1.132	1.131	1.133		
W	1.565	1.585		1.571	1.571	1.570	1.572		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SD	Audited by: JML
Date: 06/07/24	Date: 06/07/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	

DART AEROSPACE LTD	Work Order:	25915
Description: 206 Saddle, Outboard, Left side	Part Number:	D2665-1
Inspection Dwg: D2665 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

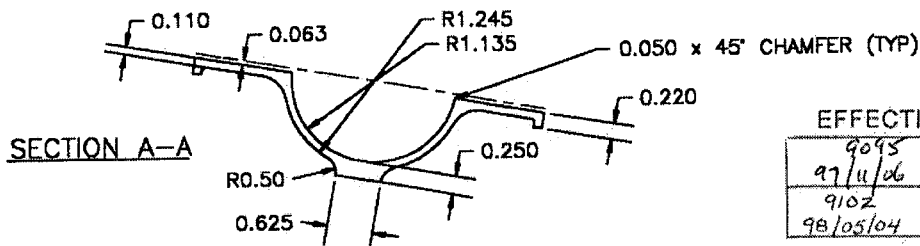
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.124	.129	.124	.127		
B	0.100	0.140		.129	.128	.129	.128		
C	0.100	0.140		.120	.121	.123	.123		
D	0.210	0.230		.223	.220	.220	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	5.990	6.010		5.995	5.995	5.995	5.995		
H	0.510	0.515		0.515	0.515	0.515	0.515		
I	1.674	1.684		1.679	1.675	1.675	1.675		
J	2.495	2.505		2.498	2.498	2.498	2.498		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		0.237	0.237	0.237	0.237		
N	0.100	0.140		.120	.117	.119	.119		
O	0.540	0.560		.546	.547	.546	.547		
P	0.490	0.510		.494	.494	.495	.495		
Q	3.609	3.619		3.614	3.614	3.614	3.614		
R	2.470	2.510		2.498	2.498	2.498	2.498		
S	0.240	0.270		.255	.255	.255	.254		
T	0.100	0.180		.144	.144	.145	.143		
U	0.313	0.318	DT8686						
V	1.125	1.145		1.133	1.132	1.131	1.132		
W	1.565	1.585		1.172	1.171	1.170	1.171		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SD	Audited by: 9m
Date: 06.07.11	Date: 06/07/24

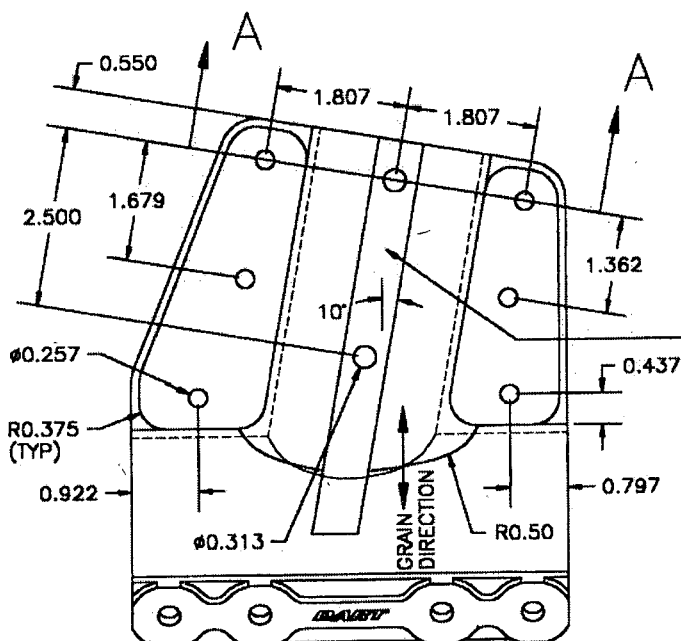
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	



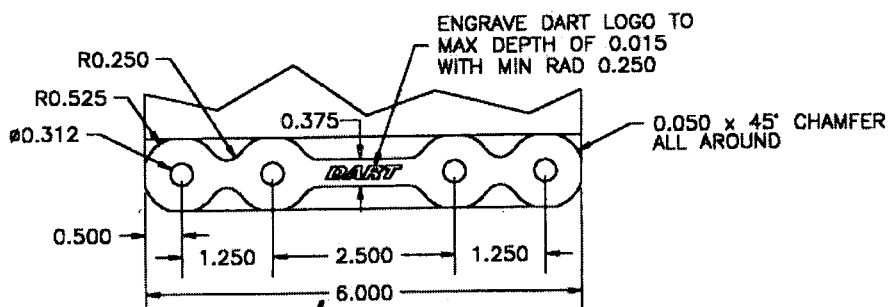
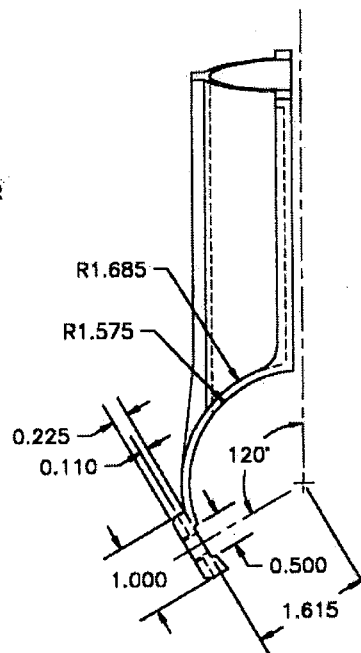
DESIGN <i>DMX</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DMX</i>	APPROVED <i>KE</i>	DRAWING NO. D2665	REV. B SHEET 1 OF 1
DATE 97.07.11		TITLE SADDLE FWD OUTSIDE HIGH	SCALE 2:5
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	



EFFECTIVE	DEOS
9095 97/11/06 DS	9122 98/12/14
9102 98/05/04 DS	



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010



ENGRAVE DART LOGO TO
MAX DEPTH OF 0.015
WITH MIN RAD 0.250

MATERIAL: ~~7075-T651~~ OR 7075-T7351 (QQ-A-250/12)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
PRIME, PAINT (EXCEPT BORES) PER DART QSI 005 4.2
NOTE: D2665-1 SHOWN (D2665-2 IS OPPOSITE)
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
97/07/16 DS
ECN 008

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25915

